

Date: Wednesday, 10/10/2007 11:03:40 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT
Job Number : 35081A	
Estimate Number : 10452	
P.O. Number :	Part Number : D32781
This Issue : 10/10/2007 S.O. No. :	Drawing Number : D3278 REV. C
Prsht Rev. : NC	Project Number : N/A
First Issue : / /	Drawing Revision : C
Previous Run : 34951A	Material :
Written By : <u>JA 07/10/10</u>	Due Date : 10/31/2007
Checked & Approved By : <u>JA 07/10/10</u>	Qty: <u>32</u> Um: Each
Comment : Est:A 04.04.19 New issue KJ/JLM est B 07.09.06 rev.c dwg EC verified by: JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"
-----	--------------------	-------------------------



Comment: Qty.: 0.2454 f(s)/Unit Total : 4.9077 f(s)

Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick

(M6061T6B1.000x02.000)

Batch: M105817mk 07/11/06

(32)

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR

Cut blank: 2.00" x 1.00" x 2.550" long

mk 07/11/06

(32)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA405 and Dwg D3278

2- Deburr and Tumble

Identify as D3278-1

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

2.1 ISSUE P/O. 3655
610BUSC208102/08 (32)

2.2 RECEIVE AND ATTACHED CARL

2.3 OC608/3/10 (30) counts
08/03/11 (13)

Form: mprocess

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 21/03/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/10/2007 11:03:40 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 35081A

Part Number: D32781

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



30X

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-J 08/03/11

7.0

POWDER COATING

POWDER COATING



FL 08/03/11

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m 107005

M-J

30

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



30X

Comment: INSPECT POWDER COAT

M-J

08/03/11

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST80

AS

08/03/12

30

10.0

QC21

FINAL INSPECTION/W/O RELEASE



30

Comment: FINAL INSPECTION/W/O RELEASE

D 08/03/12

Job Completion



m 2008/3/12

30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 35081A
Description: Support		Part Number: D3278-1
Inspection Dwg: D3278 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000					
0.359	+/-0.005					
0.609	+/-0.010					
0.250	+/-0.010					
1.480	+/-0.005					
R0.125	+/-0.010					
0.119	+0.005/-0.004					
2.439	+/-0.010					
1.980	+/-0.010					
R0.13	+/-0.030					
Ø0.257	+0.005/-0.000					
R0.375	+/-0.010					
0.875	+/-0.010					
0.500	+/-0.010					
R0.400	+/-0.010					
R1.00	+/-0.030					
1.720	+/-0.010					
R0.125	+/-0.010					
0.125	+/-0.010					

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

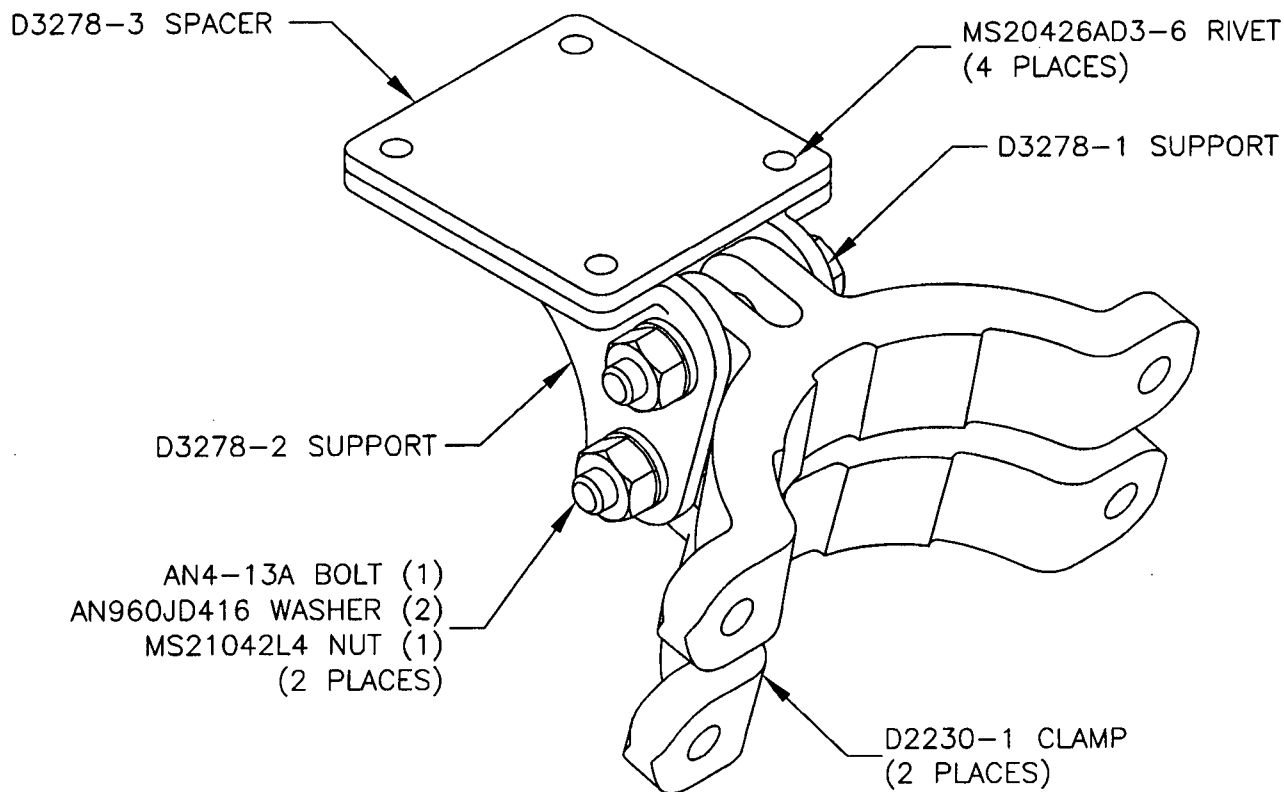
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	FE

DART

DESIGN 97	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07 08 08

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

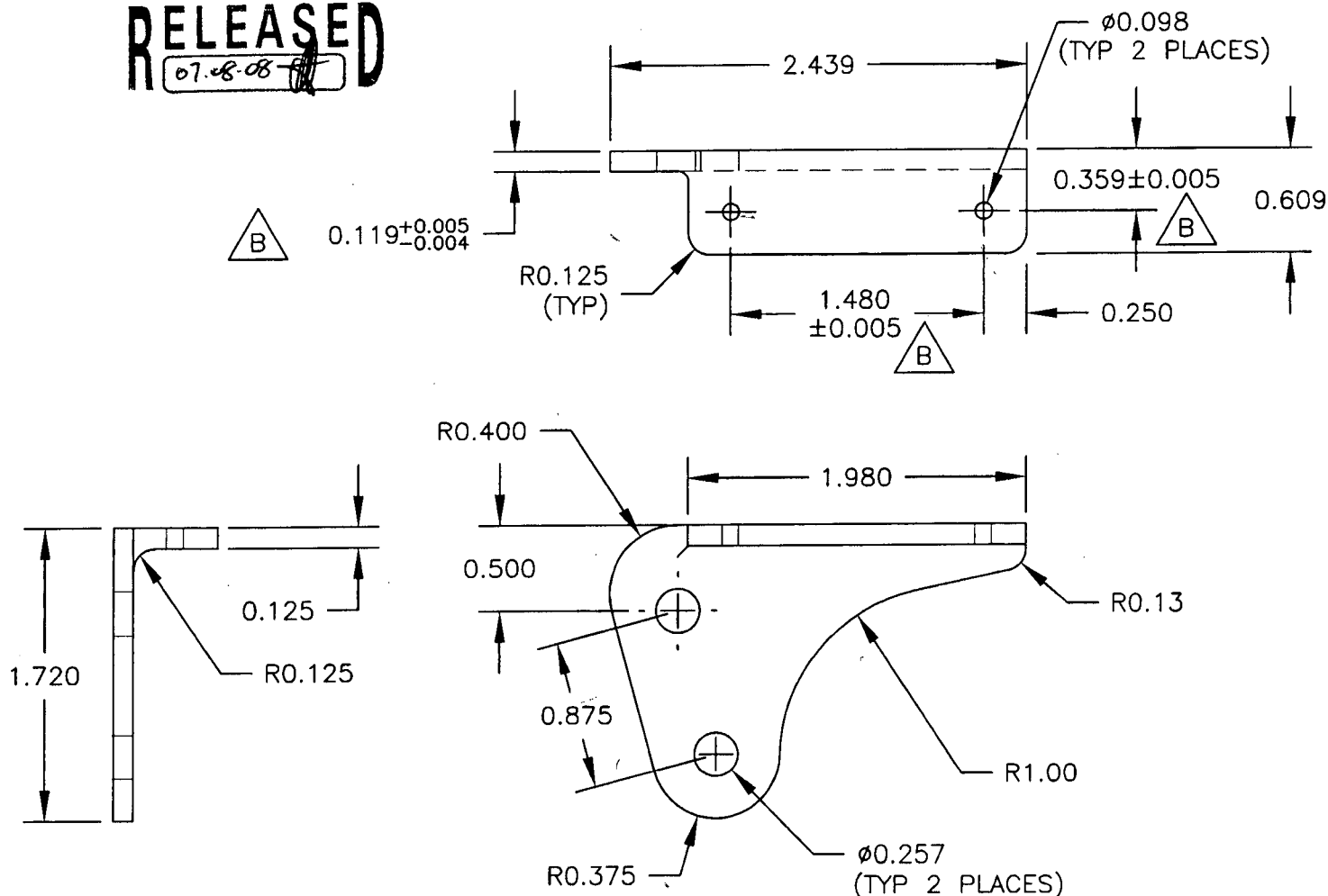
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NO. 35081A

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CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

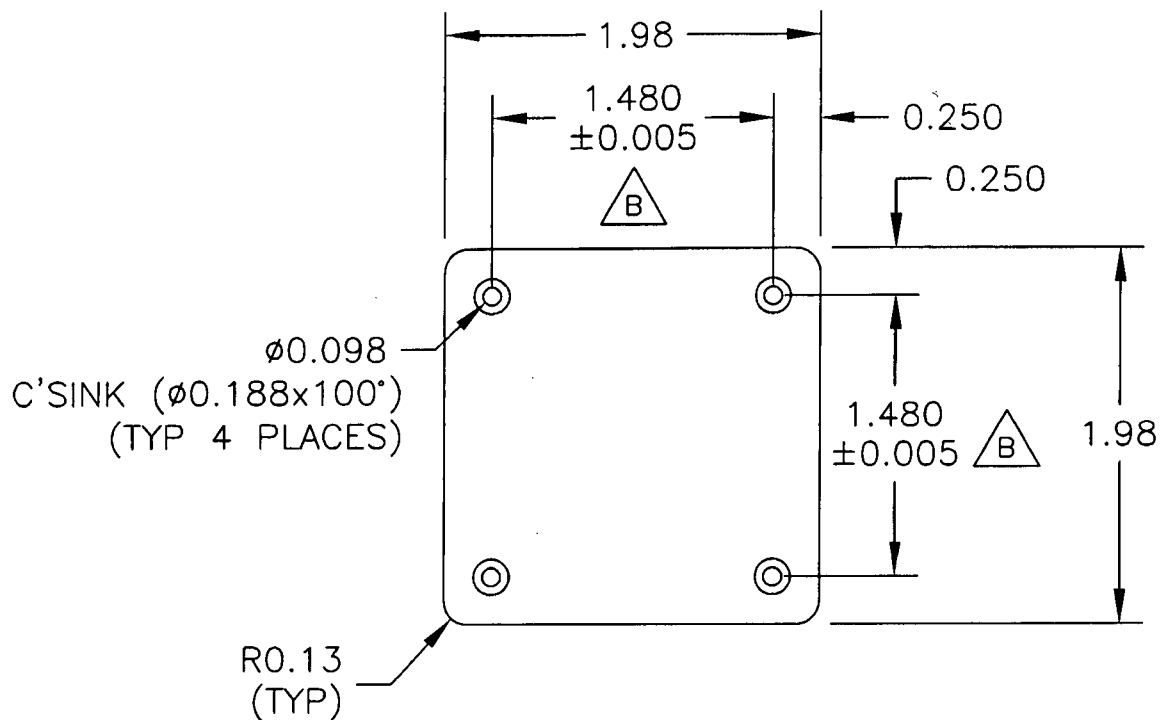
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DESIGN <i>GP</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>AB</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Invoice

DATE	INVOICE NO.
3/7/2008	16997

36 Colonnade Road N.
Ottawa, Ontario K2E 7J6
Tel: (613) 226-1579
Fax: (613) 226-1719

BILL TO <i>Dart Aerospace</i> 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7
--

SHIP TO <i>Main Finished Goods Location</i> <i>Dart Aerospace</i> 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. NO.	TERMS	SHIP DATE	SHIPPED VIA	JOB NO.	FOB
000005655	Net 30	3/7/2008	Pick-Up	632	Globus

QTY	DESCRIPTION
113	D3278-1 Rev.C Support → 112
1	Machine Setup
80	D3278-2 Rev.C Support ✓ 30 350810
1	Machine Setup
1	NRE-Programming
Business Number: 102122058	
WE CERTIFY THAT ITEMS LISTED HAVE BEEN MANUFACTURED IN ACCORDANCE WITH DRAWINGS AND PURCHASE ORDER SPECIFICATIONS	

WHITE = Original
BLUE = C of C
YELLOW = Packing Slip

Carrying Charge - 2% per Month -24% per Annum
on Overdue Accounts